

# **POWERMATIC<sup>®</sup>**

## **WMH TOOL GROUP**

### **Operating Instructions and Parts Manual**

### **24-inch Wood Planer**

Model WP2412



#### **WMH TOOL GROUP**

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**Part No. M-0460285**  
Revision B 6/04  
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This manual has been prepared for the owner and operators of a Powermatic Model WP2412 Planer. Its purpose, aside from machine operation, is to promote safety using accepted operating and maintenance procedures. To obtain maximum life and efficiency from your planer and to aid in using it safely, please read this manual thoroughly and follow the instructions carefully.

## **Warranty and Service**

WMH Tool Group warrants every product it sells. If one of our tools needs service or repair, one of our Authorized Repair Stations located throughout the United States can provide quick service or information.

In most cases, a WMH Tool Group Repair Station can assist in authorizing repair work, obtaining parts, or perform routine or major maintenance repair on your Powermatic product.

For the name of an Authorized Repair Station in your area, please call 1-800-274-6848, or visit our web site at [www.wmhtoolgroup.com](http://www.wmhtoolgroup.com)

### **More Information**

Remember, WMH Tool Group is consistently adding new products to the line. For complete, up-to-date product information, check with your local WMH Tool Group distributor, or visit our web site at [www.wmhtoolgroup.com](http://www.wmhtoolgroup.com)

### **WMH Tool Group Warranty**

WMH Tool Group makes every effort to assure that its products meet high quality and durability standards and warrants to the original retail consumer/purchaser of our products that each product be free from defects in materials and workmanship as follows: 1 YEAR LIMITED WARRANTY ON ALL PRODUCTS UNLESS SPECIFIED OTHERWISE. This Warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, repair or alterations outside our facilities, or to a lack of maintenance.

WMH TOOL GROUP LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD SPECIFIED ABOVE, BEGINNING FROM THE DATE THE PRODUCT WAS PURCHASED AT RETAIL. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OR MERCHANTABILITY AND FITNESS ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG THE IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU. IN NO EVENT SHALL WMH TOOL GROUP BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

To take advantage of this warranty, the product or part must be returned for examination, postage prepaid, to an Authorized Repair Station designated by our office. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, we will either repair or replace the product at our discretion, or refund the purchase price if we cannot readily and quickly provide a repair or replacement. We will return the repaired product or replacement at WMH Tool Group's expense, but if it is determined there is no defect, or that the defect resulted from causes not within the scope of WMH Tool Group's warranty, then the user must bear the cost of storing and returning the product. This warranty gives you specific legal rights; you may also have other rights, which vary from state to state.

WMH Tool Group sells through distributors only. Members of the WMH Tool Group reserve the right to effect at any time, without prior notice, alterations to parts, fittings and accessory equipment, which they may deem necessary for any reason whatsoever.

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# Warnings

1. Read and understand the entire owners manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace the warning labels if they become obscured or removed.
4. This planer is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a planer, do not use until proper training and knowledge have been obtained.
5. Do not use this planer for other than its intended use. If used for other purposes, WMH Tool Group disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. Always wear approved safety glasses/face shields while using this planer. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
7. Before operating this planer, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Remove all loose clothing and confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do **not** wear gloves.
8. Wear ear protectors (plugs or muffs) during extended periods of operation.
9. Some dust created by power sanding, sawing, grinding, drilling and other construction activities contain chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:
  - Lead from lead based paint.
  - Crystalline silica from bricks, cement and other masonry products.
  - Arsenic and chromium from chemically treated lumber.Your risk of exposure varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area and work with approved safety equipment, such as face or dust masks that are specifically designed to filter out microscopic particles.
10. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
11. Make certain the switch is in the **OFF** position before connecting the machine to the power supply.
12. Make certain the machine is properly grounded.
13. Make all machine adjustments or maintenance with the machine unplugged from the power source.
14. Remove adjusting tools and wrenches. Form a habit of checking to see that adjusting tools and wrenches are removed from the machine before turning it on.
15. Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately after maintenance is complete.
16. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
17. Provide for adequate space surrounding work area and non-glare, overhead lighting.
18. Keep the floor around the machine clean and free of scrap material, oil and grease.
19. Keep visitors a safe distance from the work area. **Keep children away.**

# Warnings

20. Make your workshop child proof with padlocks, master switches or by removing starter keys.
21. Give your work undivided attention. Looking around, carrying on a conversation and “horse-play” are careless acts that can result in serious injury.
22. Maintain a balanced stance at all times so that you do not fall or lean against the knives or other moving parts. Do not overreach or use excessive force to perform any machine operation.
23. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and safer.
24. Use recommended accessories; improper accessories may be hazardous.
25. Maintain tools with care. Keep knives sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
26. Turn off the machine before cleaning. Use a brush or compressed air to remove chips or debris — do not use your hands.
27. Do not stand on the machine. Serious injury could occur if the machine tips over.
28. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
29. Remove loose items and unnecessary work pieces from the area before starting the machine.

**Familiarize yourself with the following safety notices used in this manual:**

**CAUTION** This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.

**WARNING** This means that if precautions are not heeded, it may result in serious injury or possibly even death.

**-- SAVE THESE INSTRUCTIONS --**

# Introduction

This manual is provided by WMH Tool Group covering the safe operation and maintenance procedures for a Model WP2412 Powermatic Planer. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. This machine has been designed and constructed to provide years of trouble free operation if used in accordance with instructions set forth in this manual. If there are any questions or comments, please contact either your local supplier or WMH Tool Group. WMH Tool Group can also be reached at our web site: [www.wmhtoolgroup.com](http://www.wmhtoolgroup.com).

# Description

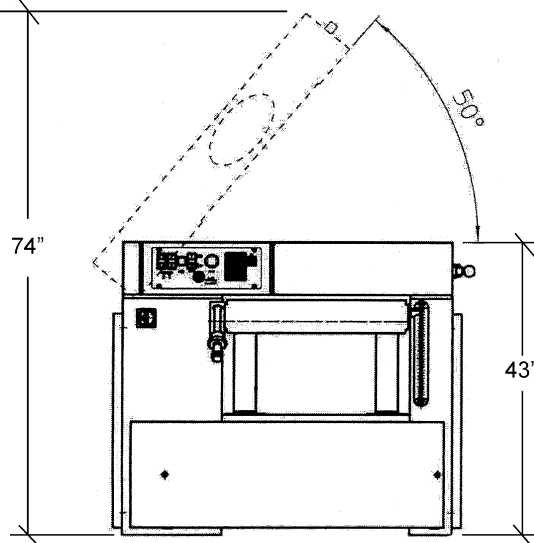
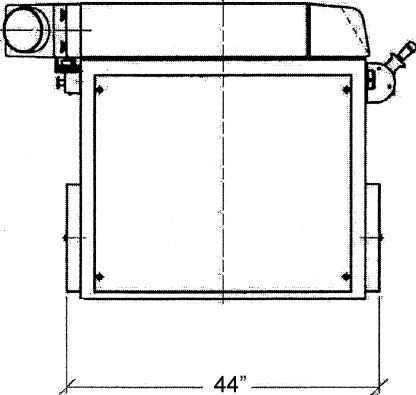
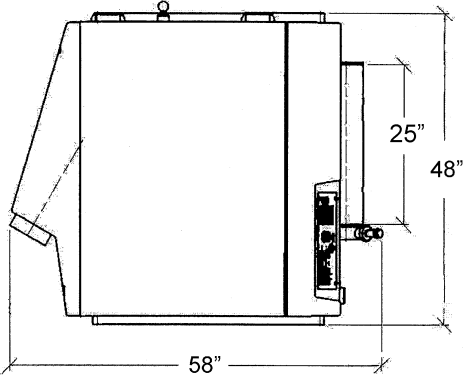
This multi-featured 15 horsepower planer is built for the rugged, industrial environment. It features a quick change Tersa™ cutterhead with reversible knives, segmented infeed roller with sectional chip breaker, and dual drive chains and sprockets. The cutterhead and infeed and outfeed rollers have double bearings. The planer frame is built with heavy plate steel, and the cast iron table is supported by four massive columns – this machine will not vibrate under load. Knife changes are quick with the self-seating knives. The planer will accomodate rough to finish work, and multiple piece planing.

# Specifications

Model Number.....	WP2412
Stock number .....	1791295
Main motor (TEFC).....	15HP, 3Ph, 230V, 60Hz, 60A
Table raising motor (TEFC).....	.075HP
Feed Motor (TEFC).....	1HP
Variable feed speed (ft/min.) .....	16 to 72
Cutterhead speed (RPM) .....	5200 RPM
Cutterhead diameter (in) .....	4.75
Knives TERSA™ (in).....	four @ 25"
Max. chip removal single pass (in) .....	0.3125
Serrated infeed roller (in) .....	2.75
Outfeed rollers (in).....	2.75
Table dimensions (in).....	24.8 x 45.6
Thickness capacity (in) .....	12
Dust port (in).....	6
Belts .....	three V-belts
Overall dimensions (in LxWxH) .....	58 x 48 x 43
Overall dimensions (crated) (in LxWxH) .....	63 x 53 x 49
Net weight (lbs).....	2,310
Shipping weight (lbs).....	2,640

The above specifications were current at the time this manual was published, but because of our policy of continuous improvement, WHM Tool Group reserves the right to change specifications at any time and without prior notice, without incurring obligations.

# WP2412 Planer Dimensions



## Unpacking

Open shipping crate and check for shipping damage. Report any damage immediately to your distributor and shipping agent. Read this instruction manual thoroughly for assembly, maintenance and safety instructions.

## Contents of the Shipping Container

- 1 Planer
- 3 Lifting hooks
- 4 Open-end wrenches (10, 13-17, 19-22, and 24mm)
- 5 Hex wrenches (4, 5, 6, 8 and 10mm)
- 1 Brass punch
- 1 Owner's manual
- 1 Warranty card



### **⚠WARNING**

Read and understand the entire contents of this manual before attempting set-up or operation! Failure to comply may cause serious injury.



# Installation

## Tools required for installation

wrench set (provided)  
level  
forklift or crane with straps

1. Remove the crate from around the planer and any fasteners securing the planer to the skid.
2. Remove the side covers and place the lifting hooks into the slots (Figure 1). Place straps under them and lift the machine off the skid. The planer should be located on a sturdy floor, preferably concrete, in a dry area with sufficient lighting. Leave enough space around the machine for loading and offloading stock and routine maintenance work.
3. When the planer is situated, use the leveling screws (Figure 2) to level the machine.
4. Exposed metal areas of the planer have been factory coated with a protectant. This should be removed with a soft cloth and kerosene. Do not use an abrasive pad. Do not let solvent contact the plastic parts of the machine, as it may damage them.



Figure 1

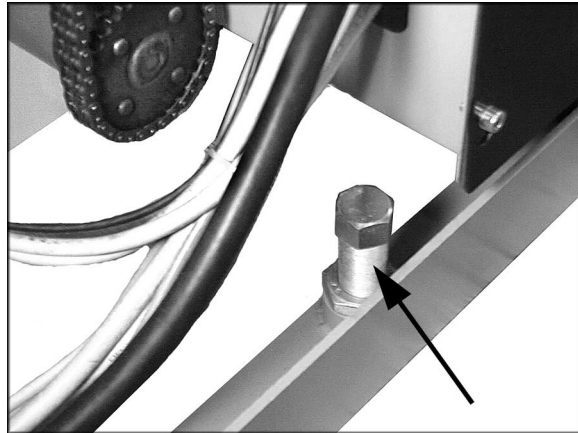


Figure 2

## Electrical Connections

**⚠WARNING** Electrical connections must be made by a qualified electrician in compliance with all relevant codes. The machine must be properly grounded to help prevent electrical shock and possible fatal injury.

The planer may be fitted with a 230 volt plug, or may be “hard-wired” directly to your electrical panel. If hard-wired to a panel, make sure a disconnect is available for the operator.

**IMPORTANT:** The 230 volt model of the WP2412 planer is wired for 230 volt only; it is not convertible to 460 volt.

1. Make sure the machine’s plug is disconnected from the power source. If it is hard-wired, make sure the fuses have been removed or the breakers have been tripped in the circuit to which the saw will be connected. Place a warning placard on the fuse holder or circuit breaker to prevent it being turned on while the machine is being wired. Always follow proper Lock Out/Tag Out procedures when performing any wiring on this machine.

2. Make sure the voltage of the power source corresponds to the voltage of the planer as recorded on the motor plate.
3. Open the electrical enclosure on the left side of the machine (Figure 3) by loosening the screws and sliding the panel upward.
4. Connect the three phases to the terminals marked L1, L2, L3 (Figure 4).
5. Connect the green neutral wire to terminal "N".
6. Connect the machine to power (or install the fuses or reset the breakers at the power source).
7. Test the rotation of the cutterhead. Turn on the main power switch (see Figure 5) and then the main motor switch (Figure 5). The pulley on the main motor (on the side near the electrical enclosure) should rotate counterclockwise. If it rotates clockwise, stop the machine with the red stop button (Figure 5).
8. Disconnect machine from power source, and exchange leads L1 and L2.
9. Reconnect power, and close the electrical cover.

## Dust Collection

It is strongly recommended this planer be connected to a dust extraction system, via the 6" (160mm) dust port at the rear of the planer. Your dust collector should have at least 1500 CFM capacity.

## Adjustments

### Controls

Figure 5 shows the control panel for the planer.

### Starting procedure

NOTE: The planer will not start if the hood is raised, or if the brake release light is on (see below).

1. Turn Main Switch to position "I". [NOTE: The main switch has a lock-out hole, through which a padlock or similar device can be inserted, when the switch is in "O" position]
2. Push the Main Motor Start button; the motor will start in Star-Delta. After a few seconds you will hear the motor switch over to full speed operation. NOTE: The inverters (see Figure 3) have been factory programmed and their settings should not be altered.

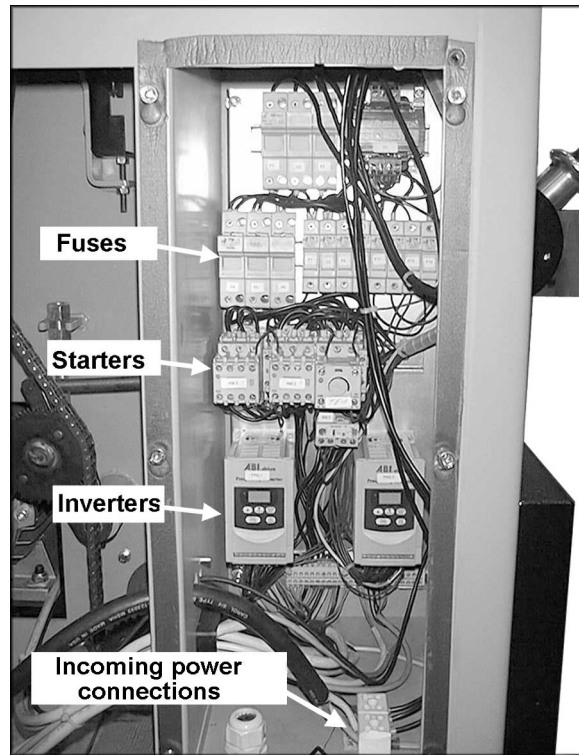


Figure 3

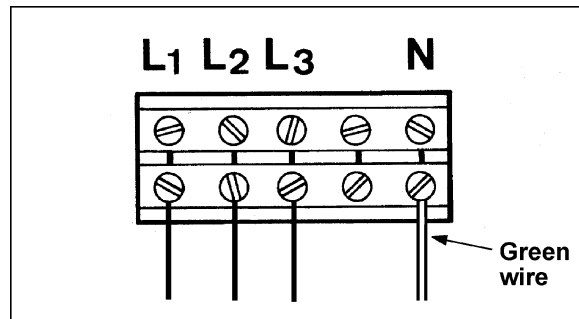


Figure 4

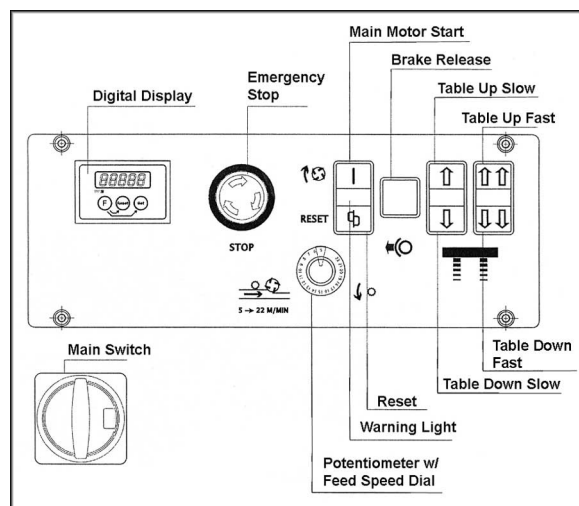


Figure 5

3. The Reset button (Figure 5) will light up if the machine becomes overloaded. Press this button to re-start the machine.
4. The Emergency Stop Button shuts down all operations on the planer. An automatic brake stops the motor within 10 seconds. A similar stop button can be found at the back of the machine. To restart the machine, simply twist the stop button and allow it to pop back up
5. To begin the feed motor and rotation of the feed rollers, press the Potentiometer button on the dial. Rotate the dial to set the feed speed. Speed ranges from 16 to 72 feet per minute. The numbers on the dial are shown as 1 to 11; the higher the number, the faster the speed. To stop the feed motor press the Potentiometer button again.
6. The Brake Release switch frees the cutterhead so that it can be moved by hand (e.g. when changing knives). When the brake release is on, the switch stays lit. As a safety feature, the planer's motor will not start if the brake release switch is lit. And if the switch is pushed during operations, the motor will automatically stop. To restart the planer, de-press the brake release switch; the light will turn off.
7. To raise the table press the up-arrow buttons; to lower the table press the down-arrow buttons. The single arrows raise the table slowly, the double arrows rapidly.

### Calibrating Digital Display

Before operating the planer, the digital display should be checked for accuracy and calibrated if necessary. Use a scrap board.

1. Set the table to just under the thickness of your scrap board, using the scale next to the table (Figure 6). Feed the board through the planer to achieve a planed side.
2. Raise the table slightly until the adjoining scale pointer is set evenly on a number.
3. Flip the board over and feed it through the planer, then carefully measure its thickness with calipers. Compare this with the digital display.
4. If the display needs correcting, press and hold "Function," and press "Reset". The display will return to zero.
5. Press and hold "Function," and press "Set" until the display shows the thickness of your board. Tapping the "Set" button will move the display by increments; holding down the "Set" button will move the display rapidly.



Figure 6

## Changing Fuses

Disconnect planer from power source, and open the electrical enclosure. Pull open the cover on a fuse holder, as shown in Figure 7, and slide out the old fuse. Replace it with a new one of the proper amperage. Close the cover.

**CAUTION** Do not use a fuse with amperage rating different than what is listed on the cover of the fuse holder.

## Changing Knives

The planer has a Tersa™ Monobloc cutterhead. Knife changing is simple, and the two-sided knives are self seating once the cutterhead begins rotating. Tersa™ knives are available from your dealer or most woodworking supply stores.

**WARNING** Do not loosen any screws on the cutterhead.

1. Push brake release button (see Figure 5). The brake release light will come on.
2. Pull out on the lever at the right side of the machine, and raise the hood.

**CAUTION** After prolonged use of the planer, the cast iron frame and areas around the cutterhead may be hot.

3. Disconnect machine from power source.
4. Rotate the cutterhead to gain access to a knife. Use the provided brass punch to gently tap down the segmented gibs, as shown in Figure 8. This will release the knife.
5. Align the knife and carefully slide it through the hole in the side of the bearing casting (Figure 9).
6. To install a new knife (or the same knife reversed for a new edge), insert it through the hole. Make sure the knife is properly seated upon the bead (Figure 8) and the ends are not protruding past the ends of the cutterhead. When the machine is started later, the gibs will automatically secure the knife in place.
7. Repeat this procedure for the other three knives.
8. Lower the hood and reconnect power to the machine. Press the brake release button (Figure 5). The warning light will go out.

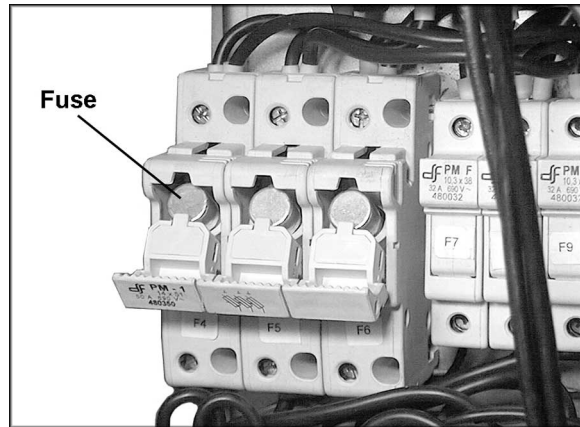


Figure 7

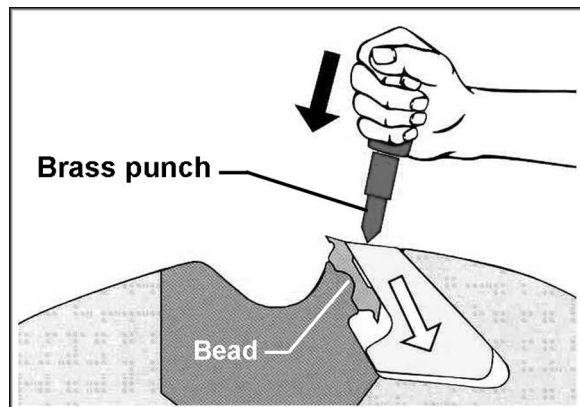


Figure 8

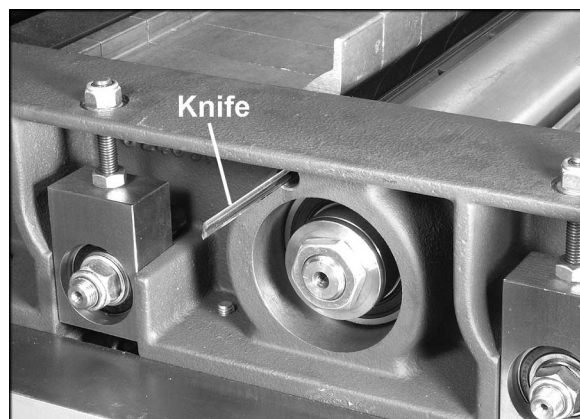


Figure 9

9. After adjusting or changing knives, the digital display should be checked and recalibrated if necessary. See “Calibrating Digital Display.”

## Belt Tension & Replacement

Note: Belts should be replaced as a matched set of three.

1. Loosen the three bolts (A, Figure 10) which hold the motor support bracket to the frame.
2. Turn the hex nuts (B, Figure 10) on the tension rod as needed.
3. When finished, tighten the three bolts (A, Figure 10).

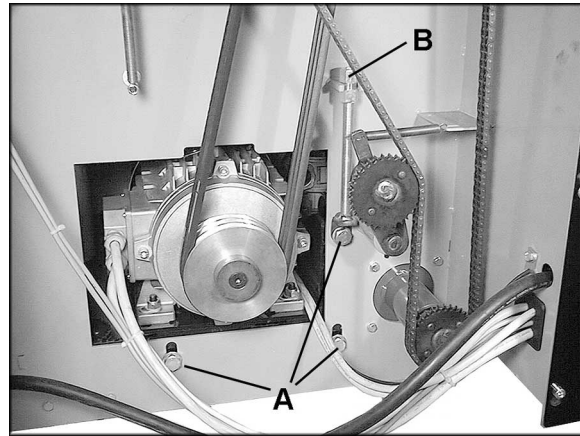


Figure 10

## Drive Chain Replacement

The drive chains do not require tension adjustment, since tension is always assured by an idle chain tensioner (C, Figure 11).

To replace the main drive chain, pull the tensioner (C, Figure 11) backward and remove the chain from around the sprockets. When the new chain has been mounted, always make sure the tensioner is well placed on the chain.

To replace the chain for the table raising mechanism, pull the lever (D, Figure 12) to the back and remove the chain. When the new chain has been mounted, push the lever (D, Figure 12) back into position.

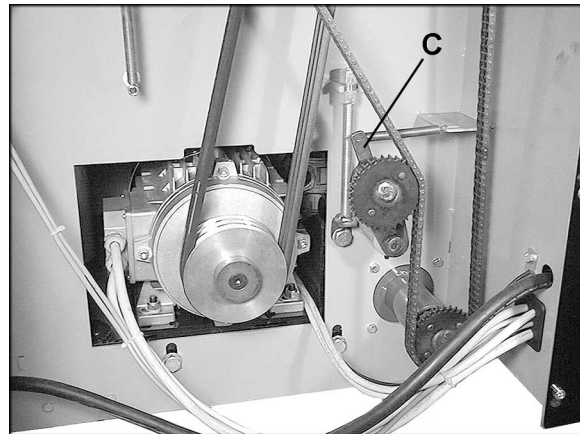


Figure 11

**CAUTION** Do not turn the sprockets on the table raising screws with the chain removed. Doing so will misalign the table.

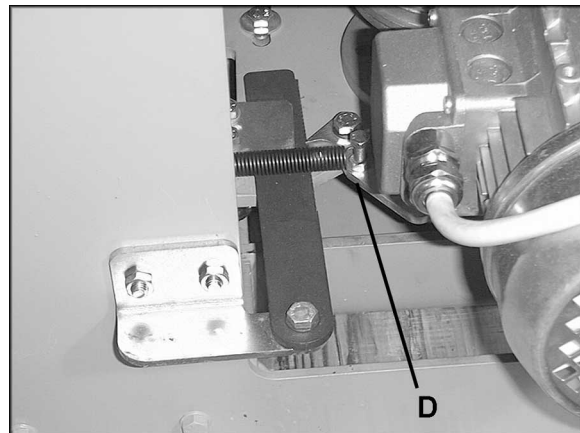


Figure 12

## Feed Rollers

The infeed and outfeed rollers and chipbreaker have been factory set. However, if spring tension adjustment should ever be necessary, use the appropriate adjustment assembly located beneath the lip of the frame – one is shown in Figure 13.

1. Loosen the nut and turn the screw in or out. When finished, tighten nut.
2. Perform the same adjustment at the opposite end of the roller.

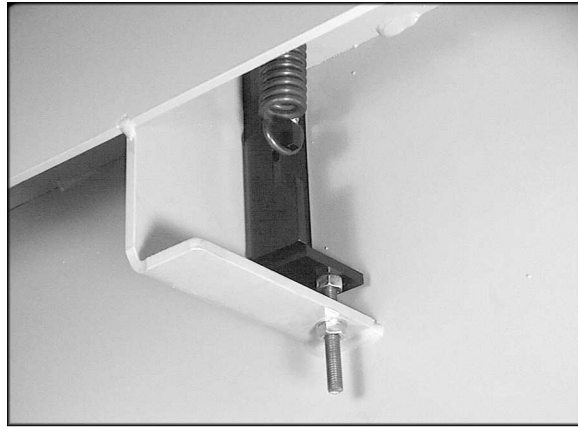


Figure 13

## Table Rollers

The table rollers can be raised or lowered with the handle (Figure 14). A label is affixed near the handle for reference.

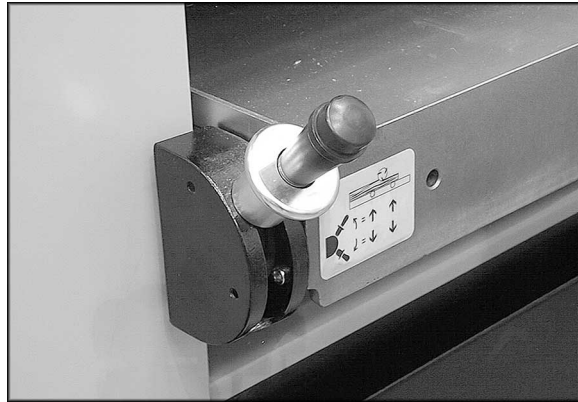


Figure 14

## Maintenance

**⚠WARNING** Before any intervention on the machine, disconnect it from the electrical supply by pulling out the plug or switching off the main switch! Follow lockout/tagout procedures. Failure to comply may cause serious injury.

The anti-kickback fingers must hang down freely and operate independently by gravity. They should be inspected frequently and cleaned whenever necessary.

The table should be kept clean and free of rust or deposits.

The lead screws and posts beneath the table, and the drive chains, should be kept clean and oiled.

Periodically blow out saw dust from the motor's cooling fan.

## Troubleshooting: Operating Problems

Trouble	Probable Cause	Remedy
Snipe (NOTE: Snipe can be minimized but not eliminated)	Table rollers not set properly.	Adjust rollers to proper height.
	Inadequate support of long boards.	Support long boards with extension rollers.
	Uneven feed roller pressure front to back.	Adjust feed roller tension.
	Dull knives.	Reverse or replace knives.
	Lumber not butted properly.	Butt end to end each piece of stock as they pass through.
Fuzzy Grain	Planing wood with high moisture content.	Remove moisture content from wood by drying, or choose other stock.
	Dull knives.	Reverse or replace knives.
Torn Grain	Too heavy a cut.	Adjust proper depth of cut.
	Knives cutting against grain.	Cut along the grain.
	Dull knives.	Reverse or replace knives.
Rough or Raised Grain	Dull knives.	Reverse or replace knives.
	Too heavy a cut.	Adjust proper depth of cut.
	Moisture content too high.	Remove moisture content from wood by drying, or choose other stock.
Rounded, glossy surface	Dull knives.	Reverse or replace knives.
	Feed speed too slow.	Increase speed.
	Cutting depth too shallow.	Increase depth.
Poor feeding of lumber	Inadequate feed roller pressure.	Adjust feed roller tension. If proper tension cannot be achieved, replace feed rollers.
	Planer bed rough or dirty.	Clean pitch and residue, and wax planer table.
	Transmission v-belt slipping.	Tighten transmission v-belt.
	Surface of feed rollers too smooth.	Lightly roughen the feed roller surface with sandpaper.
	Bed rollers too low.	Raise bed rollers to proper depth for stock.

## Troubleshooting: Mechanical & Electrical Problems

Trouble	Probable Cause	Remedy
Board thickness does not match digital display	Digital display not calibrated properly.	Follow calibration procedures.
Chain jumping	Inadequate chain tension.	Adjust chain tension.
	Sprockets misaligned.	Align sprockets.
	Sprockets worn.	Replace sprockets.
Machine will not start/restart or repeatedly trips circuit breaker or blows fuses.	No incoming power.	Verify unit is connected to power, and main switch is set to "I".
	Overload automatic reset has not reset.	When planer overloads on the circuit breaker built into the motor starter, it takes time for the machine to cool down before restart. Allow unit to adequately cool before attempting restart. If problem persists, check amp setting on the motor starter inside the electrical enclosure.
	Planer frequently trips.	One cause of overloading trips which are not electrical in nature is too heavy a cut. The solution is to take a lighter cut. If too deep a cut is not the problem, then check the amp setting on the overload relay. Match the full load amps on the motor as noted on the motor plate. If amp setting is correct then there is probably a loose electrical lead. Check amp setting on motor starter.
	Building circuit breaker trips or fuse blows.	Verify that planer is on a circuit of correct size. If circuit size is correct, there is probably a loose electrical lead. Check amp setting on motor starter.
	Loose electrical connections.	Go through all the electrical connections on the planer including motor connections, verifying the tightness of each. Look for any signs of electrical arcing which is a sure indicator of loose connections or circuit overload.
	Motor starter failure.	Examine motor starter for burned or failed components. If damage is found, replace motor starter. If motor starter looks okay but is still suspect, you have two options: Have a qualified electrician test the motor starter for function, or purchase a new starter and establish if that was the problem on changeout. <i>(continued)</i>



Trouble	Probable Cause	Remedy
Machine will not start/restart or repeatedly trips circuit breaker or blows fuses.	Motor starter failure.	If you have access to a voltmeter, you can separate a starter failure from a motor failure by first, verifying incoming voltage at 220+/-20 and second, checking the voltage between starter and motor at 220+/-20. If incoming voltage is incorrect, you have a power supply problem. If voltage between starter and motor is incorrect, you have a starter problem. If voltage between starter and motor is correct, you have a motor problem.
	Motor failure.	If electric motor is suspect, you have two options: Have a qualified electrician test the motor for function or remove the motor and take it to a qualified electric motor repair shop and have it tested.
	Miswiring of the unit.	Double check to confirm all electrical connections are correct and properly tight. The electrical connections other than the motor are pre-assembled and tested at the factory. Therefore, the motor connections should be double checked as the highest probability for error. If problems persist, double check the factory wiring.
	On/off switch failure.	If the on/off switch is suspect, you have two options: Have a qualified electrician test the switch for function, or purchase a new on/off switch and establish if that was the problem on changeout.

## **Replacement Parts**

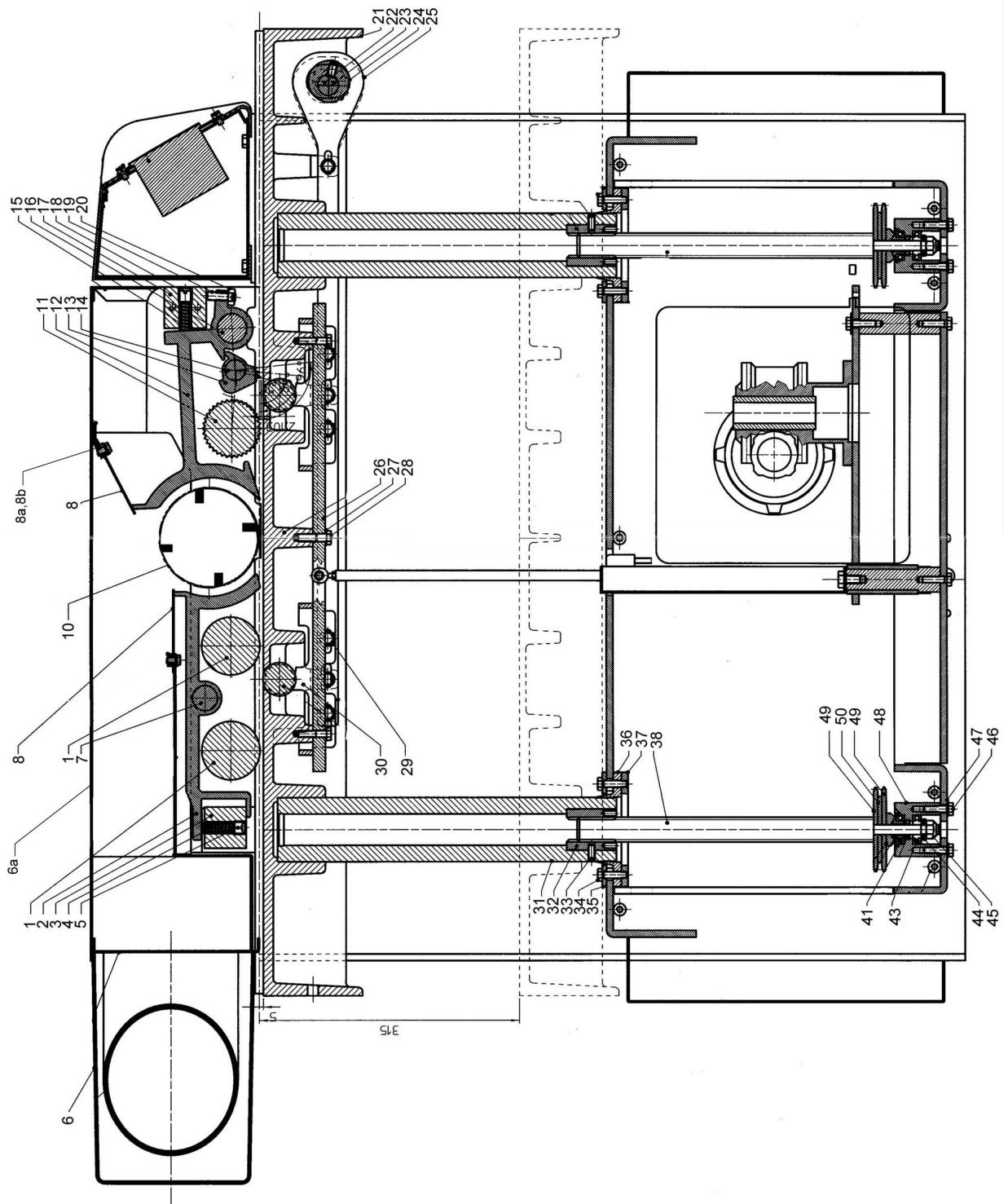
Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848 between 7:00 a.m. and 6:00 p.m. (CST), Monday through Friday. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

## Parts List: Drawing No. 1

Index No.	Part No.	Description	Size
1	WP2412-101	Outfeed Roller	
2	WP2412-102	Chipbreaker Section	
2a	WP2412-102A	Chipbreaker Section Spacer	
3	WP2412-103	Spring Bar	
3a	TS-1504081	Socket Head Cap Screw	M8 x 40
4	WP2412-104	Spring	
5	WP2412-105	Socket Set Screw	M16 x 16
6	WP2412-106	Suction Outlet Cover	
6a	WP2412-106A	Dust Hood Assembly	
7	WP2412-107	Chipbreaker Axle	
8	WP2412-108	ABS Chip Deflector	
8a	TS-1482021	Hex Cap Screw	M6 x 12
8b	TS-1550041	Flat Washer	M6
10	WP2412-110	Tersa™ Monobloc Cutterhead	
11	WP2412-111	Infeed Roller Axle	
11a	WP2412-111A	Infeed Section Spacer	
11b	WP2412-111B	Infeed Serrated Roller Section	
11c	WP2412-111C	Infeed Roller Section Spring	
11d	WP2412-111D	Complete Infeed Roll Assembly	
12	WP2412-112	Chipbreaker Section	
12a	WP2412-112A	Chipbreaker Section Spacer	
13	WP2412-113	Anti-Kickback Finger	
13a	WP2412-113A	Anti-Kickback Finger Spacer	
14	WP2412-114	Anti-Kickback Finger Axle	
15	WP2412-104	Spring	
16	WP2412-116	Chipbreaker Axle	
17	WP2412-103	Spring Bar	
17a	TS-1504081	Socket Head Cap Screw	M8 x 40
18	WP2412-105	Socket Set Screw	M16 x 16
19	TS-2279351	Socket Set Screw	M10 x 35
20	TS-1540071	Hex Nut	M10
21	WP2412-121	Planer Table	
22	TS-1525041	Socket Set Screw	M10 x 20
23	WP2412-123	Roller Actuator Axle	
24	WP2412-124	Roller Raise Eccentrics	
25	WP2412-125	Roller Raise Actuator	
26	WP2412-126	Strip	
27	TS-1550061	Flat Washer	M8
28	TS-1490061	Hex Cap Screw	M8 x 35
29	WP2412-129	Spacer	
30	WP2412-130	Right Brace	
30a	WP2412-130A	Left Brace	
31	WP2412-131	Table Column	
32	WP2412-132	Table Raise Nut	
33	TS-1524051	Socket Set Screw	M8 x 20
34	TS-1490031	Hex Cap Screw	M8 x 20
35	WP2412-135	Upper Column Disc	
36	WP2412-136	Table Column Seal Ring	
37	WP2412-137	Lower Column Backup Disc	
38	WP2412-138	Table Raising Screw	
38a	WP2412-138A	Table Raising Screw Assembly	
41	BB-51104	Table Raise Screw Bearing	51104
43	BB-51104	Table Raise Screw Bearing	51104
46	TS-1490051	Hex Cap Screw	M8 x 30
47	TS-1550061	Flat Washer	M8
48	WP2412-148	Bearing Housing	

<b>Index No.</b>	<b>Part No.</b>	<b>Description</b>	<b>Size</b>
49	WP2412-149	Table Raise Sprocket	
50	WP2412-150	Spacer Disc	
	WP2412-151	Top Cover Plate (not shown)	
	WP2412-152	Rear Frame Reinforcement (not shown)	
	WP2412-153	Top Cover Corner Strip (not shown)	
	WP2412-154	Brass Punch - Knife Change (not shown)	

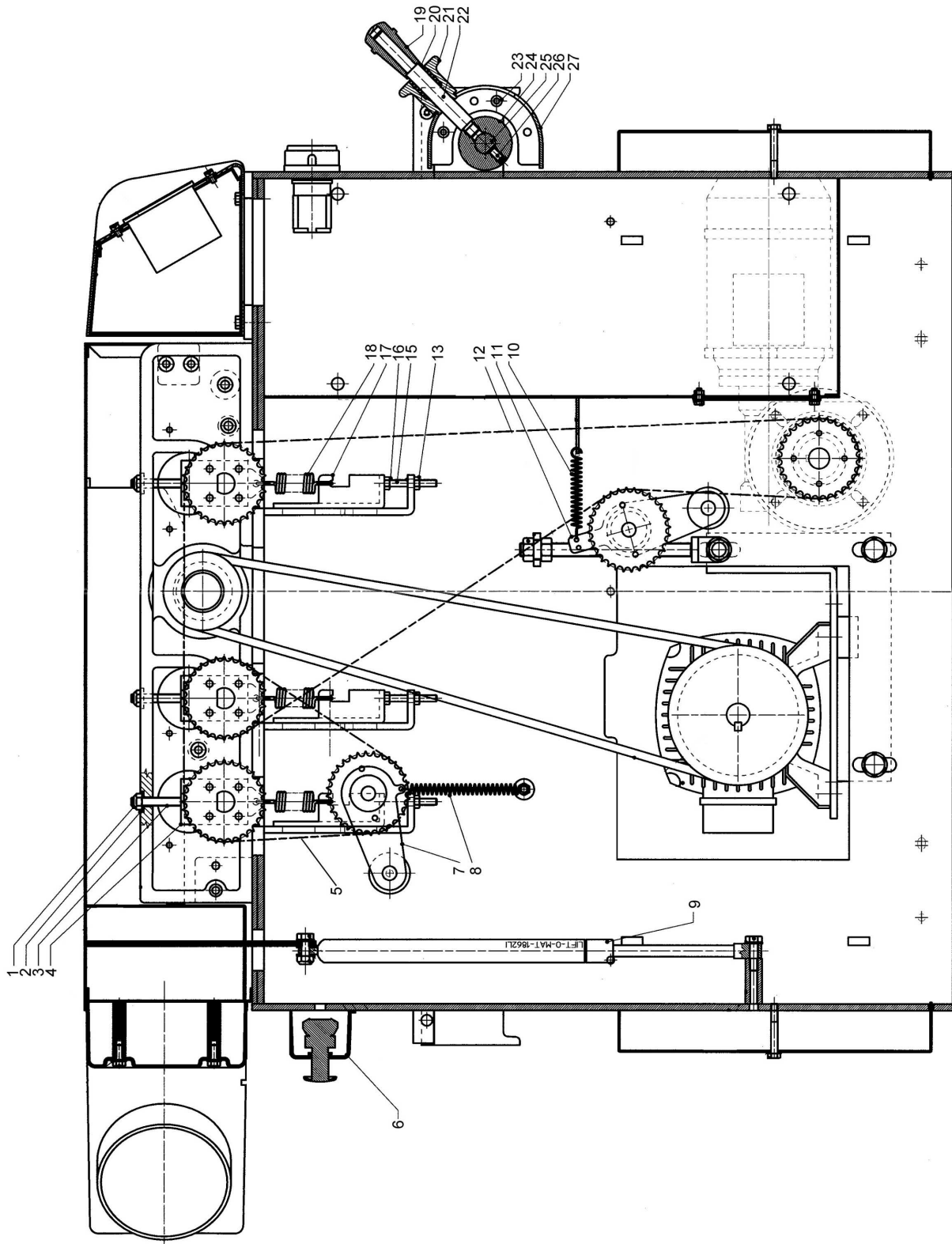
Drawing No. 1



## Parts List: Drawing No. 2

Index No.	Part No.	Description	Size
1	TS-1541041	Nylon Insert Locknut	M10
2	TS-1550071	Flat Washer	M10
3	WP2412-203	Upper Feed Roller Adjust Stud	
4	WP2412-204	Feed Roller Bearing Housing	
5	WP2412-205	Outfeed Roller Feed Chain	
6	WP2412-206	E-Stop Housing	
7	WP2412-207	Short Chain Tensioner Assembly	
8	WP2412-208	Tensioner Spring	
9	WP2412-209	Hood Raising Lift	
10	WP2412-208	Tensioner Spring	
11	WP2412-211	Long Chain Tensioner Assembly	
12	WP2412-212	Feed Chain	
13	TS-1541031	Nylon Insert Locknut	M8
15	WP2412-215	Lower Feed Roller Adjust Stud	
16	TS-1540061	Hex Nut	M8
17	WP2412-217	Feed Roller Pressure Bracket	
18	WP2412-218	Feed Roller Pressure Spring	
19	WP2412-219	Table Roller Handle	
20	WP2412-220	Handle Spring	
21	WP2412-221	Locking Handle	
22	WP2412-222	Lever	
23	TS-1504041	Socket Head Cap Screw	M8 x 20
24	WP2412-224	Bushing	
25	WP2412-123	Roller Actuator Axle	
26	TS-1525041	Socket Set Screw	M10 x 20
27	WP2412-227	Handle Cover Plate	

Drawing No. 2

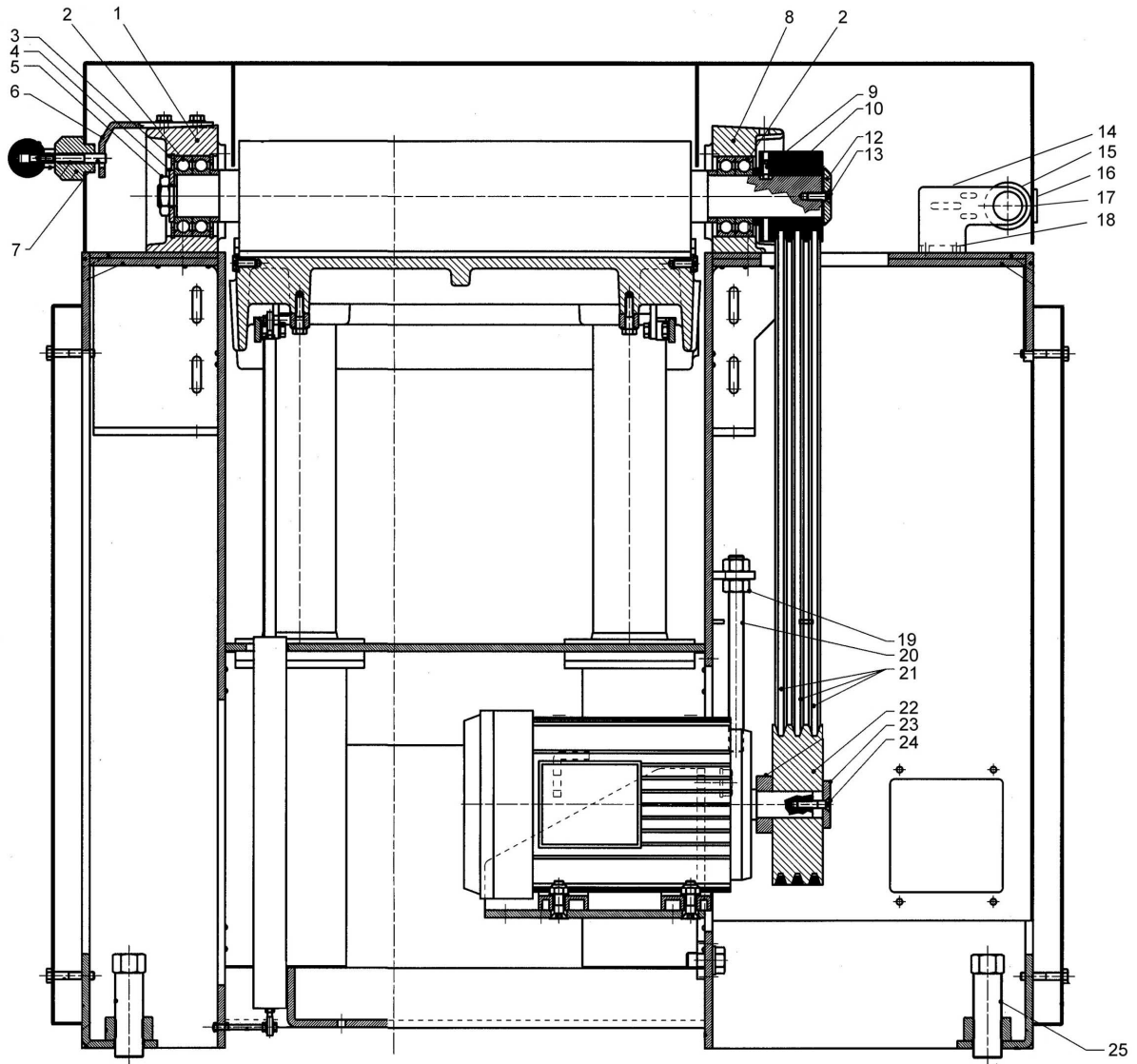


### Parts List: Drawing No. 3

Index No.	Part No.	Description	Size
1	WP2412-301	Main Bearing Housing, Left	
2	BB6209VV	Cutterhead Bearing	6209-2RS
3	WP2412-303	Retaining Ring	
4	WP2412-304	Disc	
5	TS-2312241	Hex Jam Nut	M24
6	WP2412-306	Hood Latch	
7	WP2412-307	Hood Latch Pin	
8	WP2412-308	Main Bearing Housing, Right	
9	TS-1524051	Socket Set Screw	M8 x 20
10	WP2412-310	Cutterhead Pulley	
12	WP2412-312	Disc	
13	TS-1515031	Socket Head Flat Screw	M8 x 25
14	WP2412-314	Hood Hinge	
15	WP2412-315	Hinge Pin, Front	
15a	WP2412-315A	Hinge Pin, Rear	
16	WP2412-316	Hinge Reinforcement Plate	
17	TS-1515031	Socket Head Flat Screw	M8 x 25
18	TS-1504041	Socket Head Cap Screw	M8 x 20
19	WP2412-319	Adjustment Nut	
20	WP2412-320	Belt Adjustment Rod	
21	WP2412-321	Drive Belts	
22	WP2412-322	Motor Pulley	38mm arbor dia.
23	WP2412-323	Washer	
24	TS-1515041	Socket Head Flat Screw	M8 x 30
25	WP2412-325	Frame Leveling Bolt	
25a	WP2412-325A	Leveling Bolt Nut	



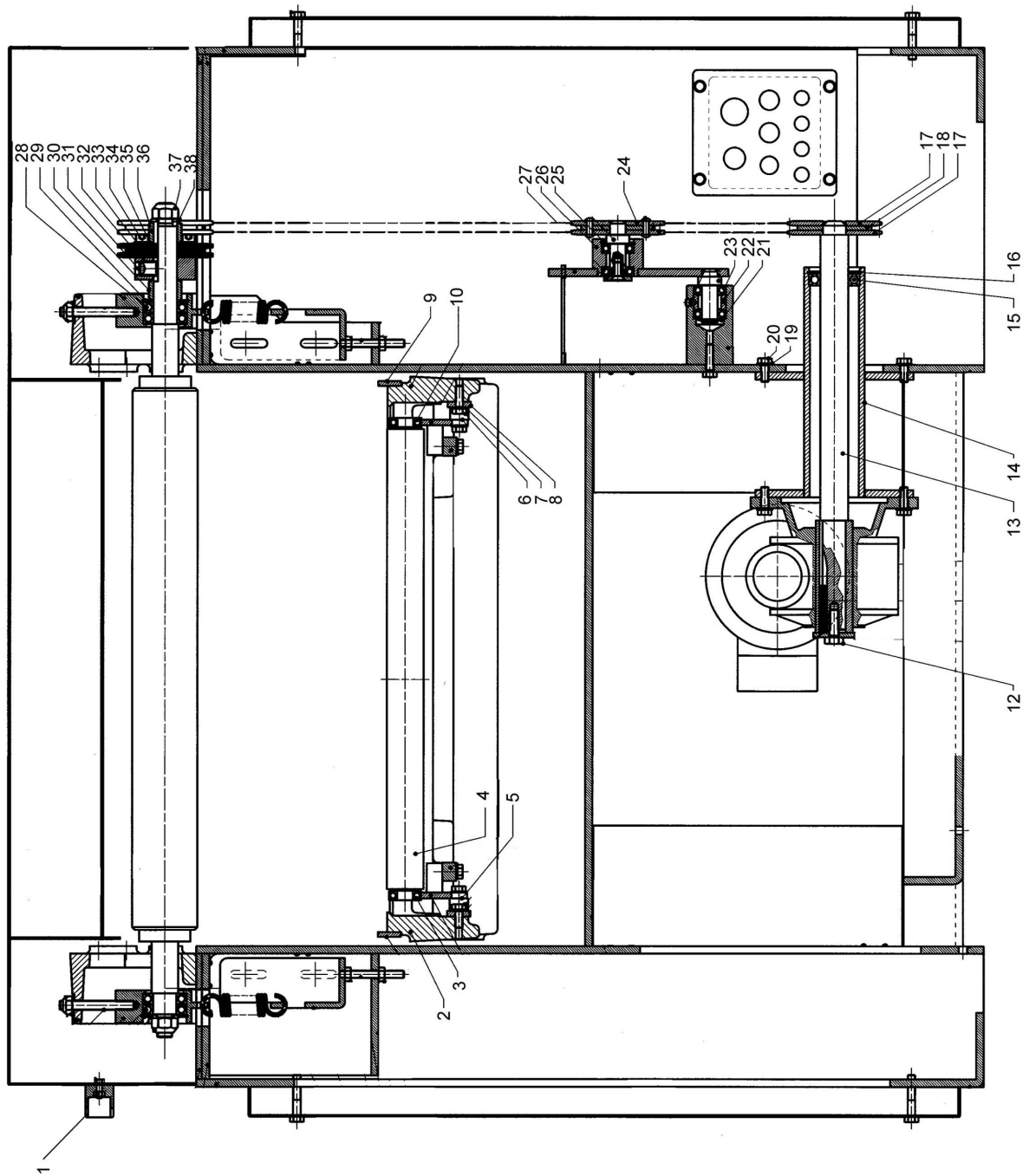
Drawing No. 3



## Parts List: Drawing No. 4

Index No.	Part No.	Description	Size
1	WP2412-401	Hood Handle	
2	WP2412-121	Planer Table	
3	BB6003V V	Table Roller Bearing	6003-2RS
4	WP2412-404	Table Roller	
5	WP2412-405	Bushing	
6	TS-1490041	Hex Cap Screw	M8 x 25
7	TS-1550061	Flat Washer	M8
8	WP2412-125	Roller Raise Actuator	
9	WP2412-409	Side Strip	
10	BB6003V V	Table Roller Bearing	6003-2RS
12	TS-1491041	Hex Cap Screw	M10 x 30
13	WP2412-413	Feed Axle	
14	WP2412-414	Feed Unit Assembly	
15	BB-6006V V	Feed Unit Bearing	6006-2RS
16	WP2412-416	Retainer Ring	
17	WP2412-417	Sprocket	
18	WP2412-418	Sprocket Spacer	
19	TS-1550061	Flat Washer	M8
20	TS-1490031	Hex Cap Screw	M8 x 20
21	WP2412-421	Retaining Ring	
22	WP2412-422	Spacer	
23	BB-6003V V	Bearing	6003-2RS
24	WP2412-424	Sprocket Assembly	
25	WP2412-425	Retainer Ring	
26	WP2412-426	Bushing	
27	BB-6003V V	Bearing	6003-2RS
28	BB-6005V V	Feed Roller Bearings	6005-2RS
29	WP2412-429	Retaining Ring	
30	WP2412-430	Bushing	
31	WP2412-105	Socket Set Screw	M16 x 16
32	WP2412-432	Outfeed Roller Sprocket Mount	
32a	WP2412-432A	Infeed Roller Sprocket Mount	
33	WP2412-433	Sprocket	
34	WP2412-434	Spacer	
35	WP2412-433	Sprocket	
36	WP2412-436	Bushing Spacer	
37	TS-2342161	Nylon Insert Locknut	M16
38	TS-155010	Flat Washer	M16

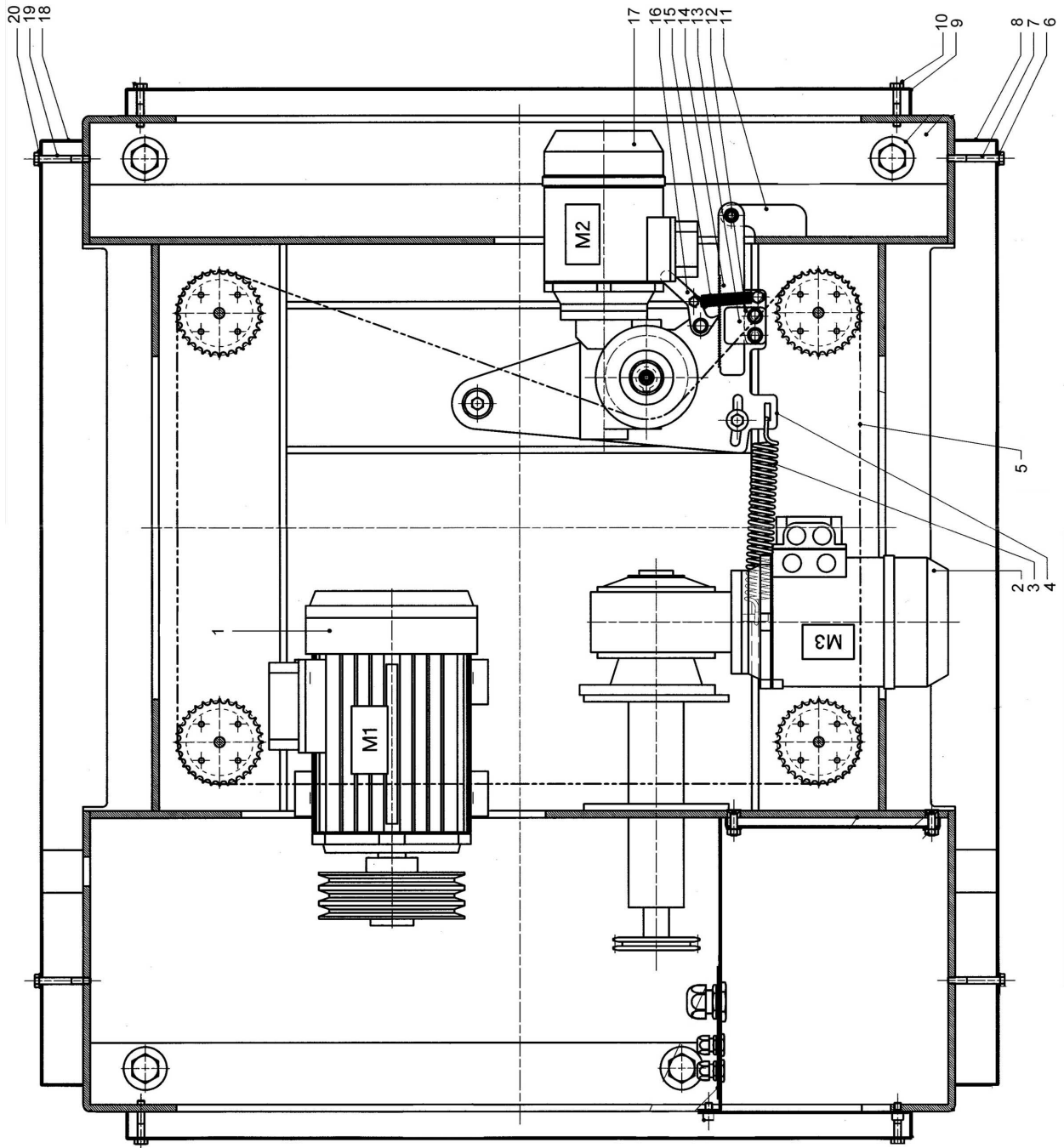
Drawing No. 4



## Parts List: Drawing No. 5

Index No.	Part No.	Description	Size
1	WP2412-501	Main Motor	15HP, 230V, 3Ph
2	WP2412-502	Feed Motor with Reducer	1HP
3	WP2412-503	Spring	
4	WP2412-504	Gear Box Mounting Plate	
5	WP2412-505	Table Raising Chain	
6	TS-1550061	Flat Washer	M8
7	TS-1490111	Hex Cap Screw	M8 x 60
8	WP2412-508	Front Cover	
9	WP2412-509	Side Cover	
10	TS-1490081	Hex Cap Screw	M8 x 45
11	WP2412-511	Plate	
12	WP2412-512	Plate Spanner	
13	WP2412-513	Support Plate	
14	WP2412-514	Toothed Lever	
15	WP2412-515	Spring	
16	WP2412-516	Adjustment Pawl	
17	WP2412-517	Table Raise Motor with Reducer	3/4HP
18	WP2412-518	Rear Cover	
19	TS-1490111	Hex Cap Screw	M8 x 60
20	TS-1550061	Flat Washer	M8
	WP2412-LH	Lifting Hooks (not shown)	

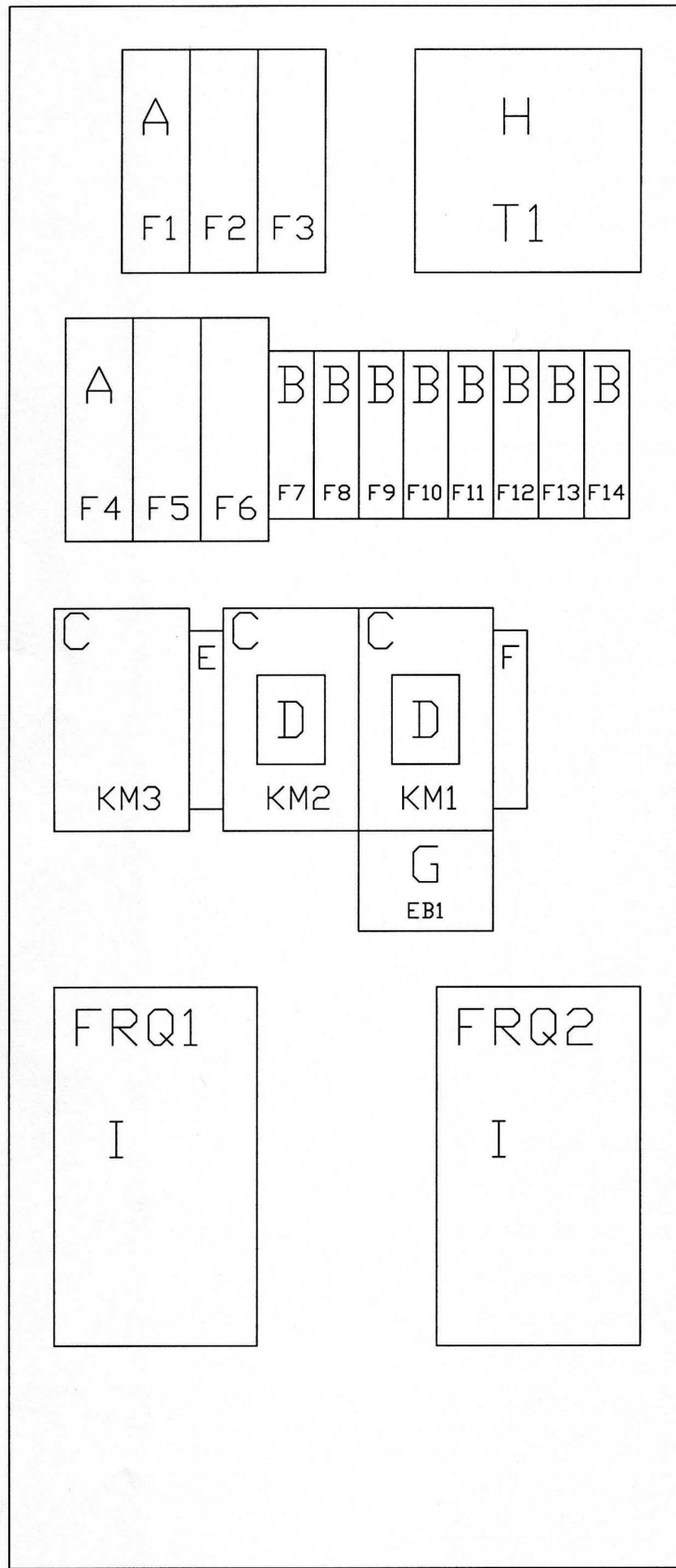
Drawing No. 5



## Parts List: Electrical Box

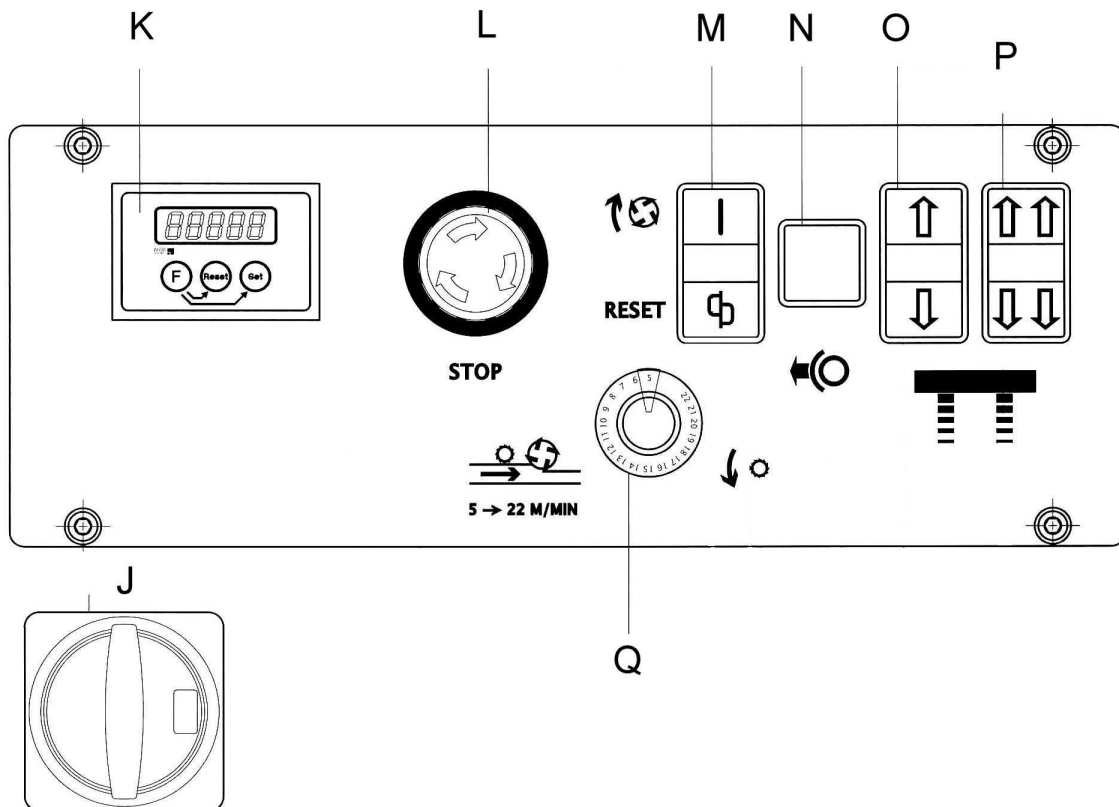
Index No.	Part No.	Description	Size
A	WP2412-601	Fuse Holder	3 poles, 50 A
B	WP2412-602	Fuse Holder	1 pole, 32A
C	WP2412-603	Magnetic Starter	
D	WP2412-604	Auxiliary Contact	
E	WP2412-605	Mechanical Interlock between Mag. Starters	
F	WP2412-606	Timer Relay Star-Delta	
G	WP2412-607	Thermal Overload Relay	
H	WP2412-608	Transformer	
I	WP2412-609	Frequency Variator	

# Electrical Box



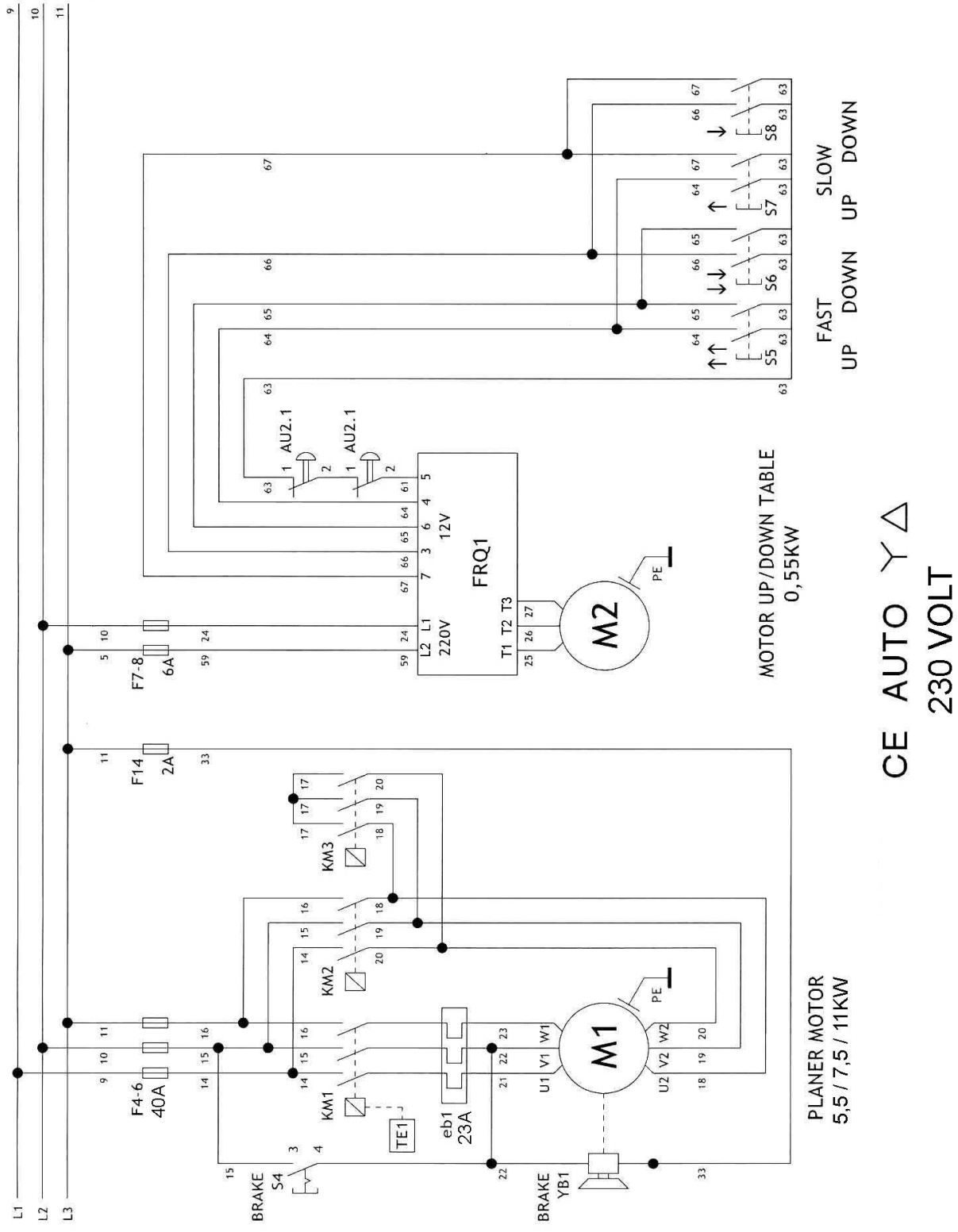
## Parts List: Control Panel

Index No.	Part No.	Description	Size
J	WP2412-701	Main On-Off Switch	
K	WP2412-702	ELGO Read-out Z 20	
L	WP2412-703	E-Stop Operator	
M	WP2412-704	Motor On/Table Reset Operator	
N	WP2412-705	Brake Release Operator	
O	WP2412-706	Table Slow Operator	
P	WP2412-707	Table Fast Operator	
Q	WP2412-708	Potentiometer	
	WP2412-709	ELGO Magnetic Tape	
	WP2412-710	Sensor Cable	
	WP2412-711	Hood Limit Switch	
	WP2412-712	Fuse	50A
	WP2412-713	Fuse	40A
	WP2412-714	Fuse	6A
	WP2412-715	Fuse	2A
	WP2412-716	Fuse	1A
	WP2412-717	Open Contact	
	WP2412-718	Closed Contact	

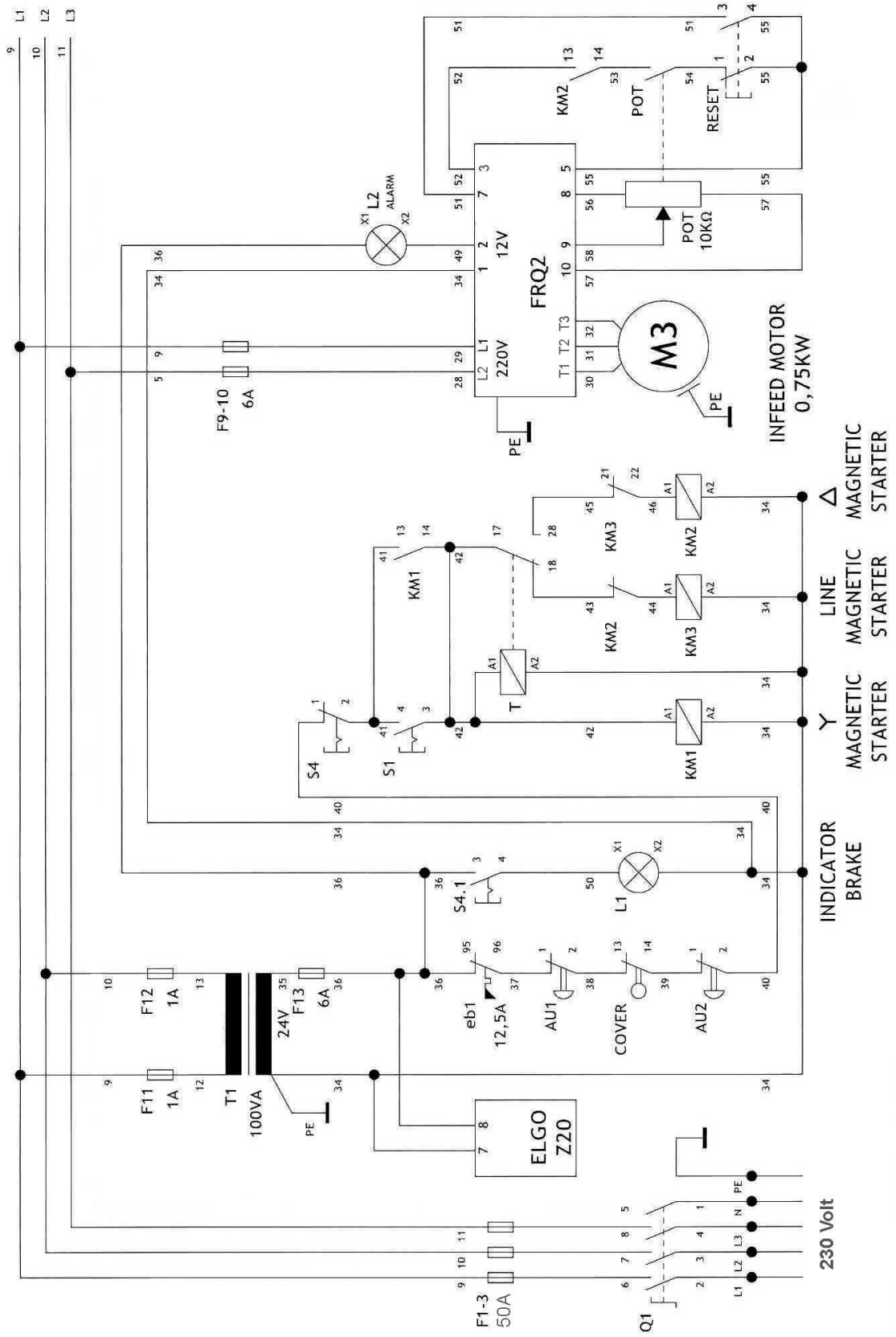




# Electrical Connections – 230 Volt



# Electrical Connections – 230 Volt



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230 Volt



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